

Date: Wednesday, 10/25/2006 11:13:28 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET ASSEMBLY
 Job Number : 29155
 Estimate Number : 11029
 P.O. Number : *N/A* Part Number : D2803041
 This Issue : 10/25/2006 S.O. No. : *N/A* Drawing Number : D2803 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : *N/A* Type : PURCHASED PARTS Drawing Revision : B
 Previous Run : 27282 Material : *N/A*
 Written By : *[Signature]* Due Date : 11/1/2006 Qty: *3* Um: Each
 Checked & Approved By : *[Signature]*
 Comment : EST F 0503.30 MS21043-3 was MS21042L3 KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D28031 STA 84 Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 STA 84 BRACKET

Pick:

Qty	Part Number	Description	Batch
1	D2803-1	Bracket	<i>(2) A 27784 (1) B 28414</i>

2.0 D28051 Stop



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 STOP

Pick:

Qty	Part Number	Description	Batch
1	D2805-1	Stop	<i>B 27664</i>

3.0 D2809 Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Bushing

Pick:

Qty	Part Number	Description	Batch
1	D2809	Bushing	<i>B 28629</i>


Press D2805-1 into arm as per Dwg D2803

4.0 *QCS* INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
06-10-30	4.0	QCS, not 2. Permanent change					 06-10-30	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/25/2006 11:13:28 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 29155

Part Number: D2803041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

POWDER COATING

POWDER COATING



M101575



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Y 06/10/30 x 3

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 06/10/30

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2809 into arm as per Dwg D2803

MF 06/10/31

8.0

AN3C16A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Pick:

Qty Part Number Description Batch

2 AN3C16A Bolt

M101064

MF 06/10/31

9.0

MS210433

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Pick:

Qty Part Number Description Batch M 100218

2 MS21043-3 Nut

M101390

MF 06/10/31

10.0

NAS1515H3

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

4 - NAS1515H3 Washer

M100993

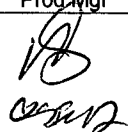
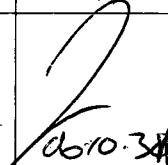
A/R LPS-3 Corrosion Spray


M101472

Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2803

MF 06/10/31

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/10/31	11	Applied LPS Hardcoat on washers & nut <u>m 17045</u>	M.F.	06/10/31	3		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/10/31
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/25/2006 11:13:28 AM
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Drawing Name: BRACKET ASSEMBLY

Job Number: 29155

Part Number: D2803041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D2803.

MF- 06/10/31 (3)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/10/31 (3)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

ST189 06/10/31 (3)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/10/31 (3)

Job Completion



CL 06/10/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

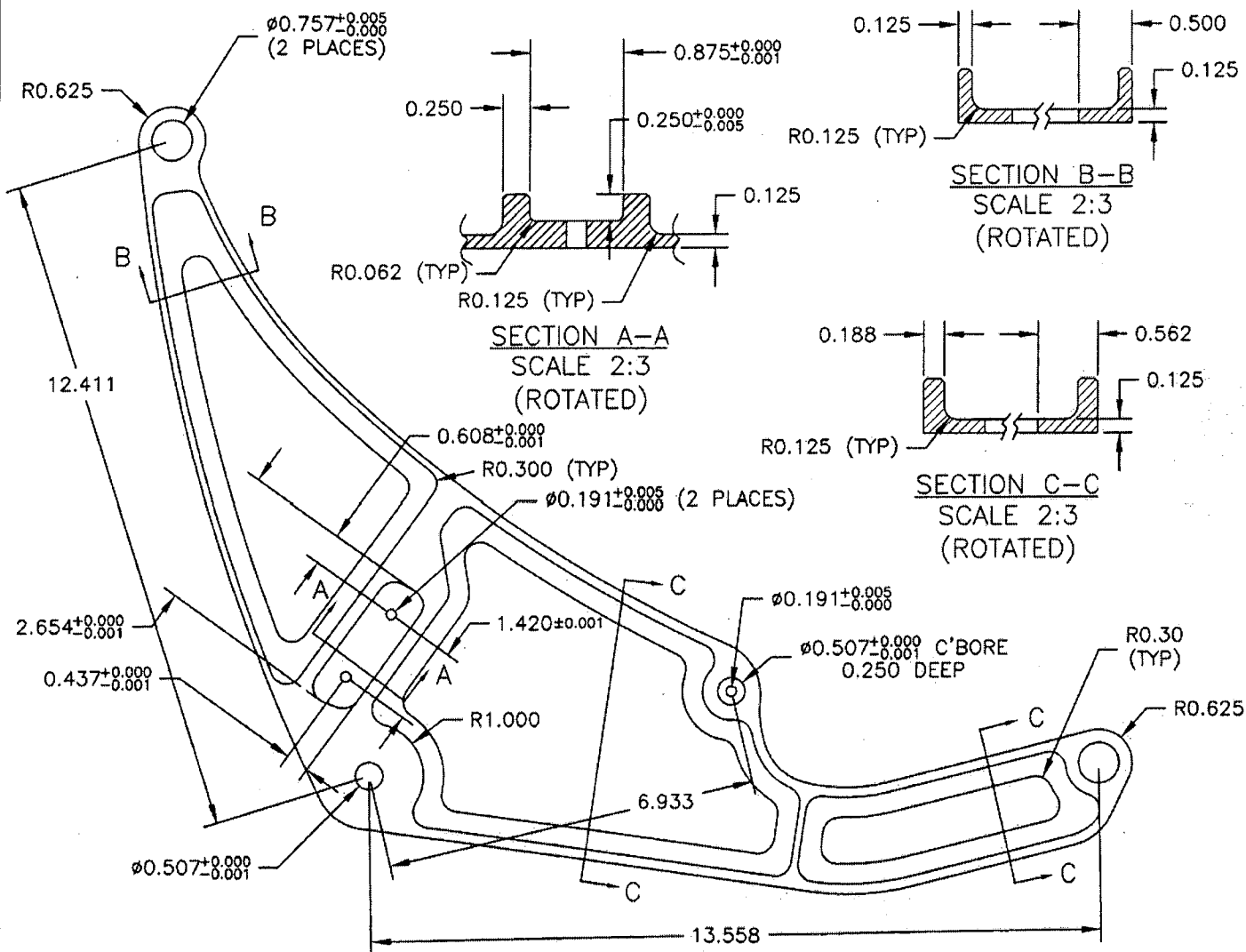
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	REV. B
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	D2803	SHEET 1 OF 2
DATE	04.11.22	TITLE	STA 84 BRACKET	SCALE	1:3
A	00.11.07	NEW ISSUE			
B	04.11.22	ADD CUTOUTS & -043/-044			

RELEASED

05-03-11 *[Signature]***D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

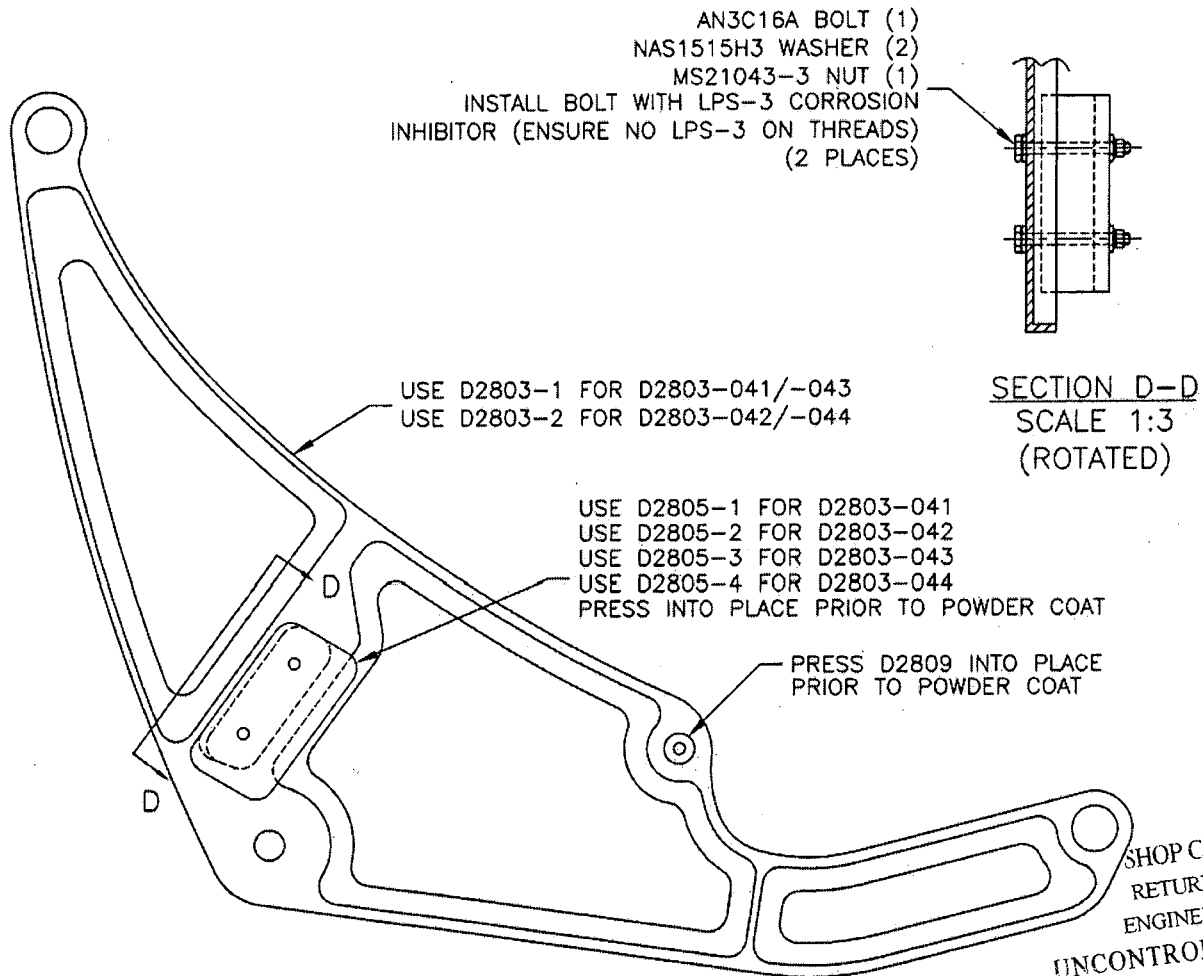
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29155

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DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3



SECTION D-D
SCALE 1:3
(ROTATED)

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RETURN TO
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WORK ORDER

RELEASED 29155

05-03.11 [Signature]

D2803-041/-043 BRACKET ASS'Y (SHOWN).
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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